

# Work Order ID 51354

August 20, 2009 8:54:35 AM



Page 1

Item ID: D3278-2

Accept



Setup Start



Revision ID: C

Stop



Item Name: Support

Start Date: 21/08/2009 Start Qty: 40.00

Cust Item ID:

Required Date: 26/08/2009 Req'd Qty: 40.00

Customer:

Reference: *49*  
*26/08.08.20*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3278	Rev C
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100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blank: 2.00" x 1.00" x 2.550" long

*mmw*  
*09/08/20*

*49*  
*0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA405 and Dwg D3278-2- Deburr and  
Tumble Identify as D3278-2

*mk 09/08/21*

*49*  
*0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*mk 09/08/21*

*49*  
*0*

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Page 2

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Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mmw  
09/08/21

49

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

x49

mp

09/08/24

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M112260

ell 09/08/24

x49

Ø

START TIME: 2:45pm OVEN TEMPERATURE:  
3:15pm FINISH TIME: 3:26pm

**Work Order ID 51354**

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Item ID: D3278-2

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Start Date: 21/08/2009 Start Qty: 40.00

Required Date: 26/08/2009 Req'd Qty: 40.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	BR 09-08-24			(49)			
170  Packaging Packaging	Identify as per dwg & Stock Location: 78  Memo	0.00  0.00							09/08/20 (44)
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00	09/08/26 J						pl 09-8-25

# Picklist Print

Page 1

August 20, 2009 8:54:35 AM

Work Order ID: 51354



Parent Item: D3278-2RevC



Parent Item Name: Support

Start Date: 21/08/2009

Required Date: 26/08/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	42.1700	9.8400			



6061-T6 Bar 1.00 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

42.17

107129

7.03

110829

2.14

111571

33

*MWF*  
*09/08/09*

*12 blocks = 2.4544*  
*6.2475 + 1.9125*

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<i>51354</i>
<b>Description: Support</b>		<b>Part Number:</b>	<b>D3278-2</b>
<b>Inspection Dwg: D3278</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

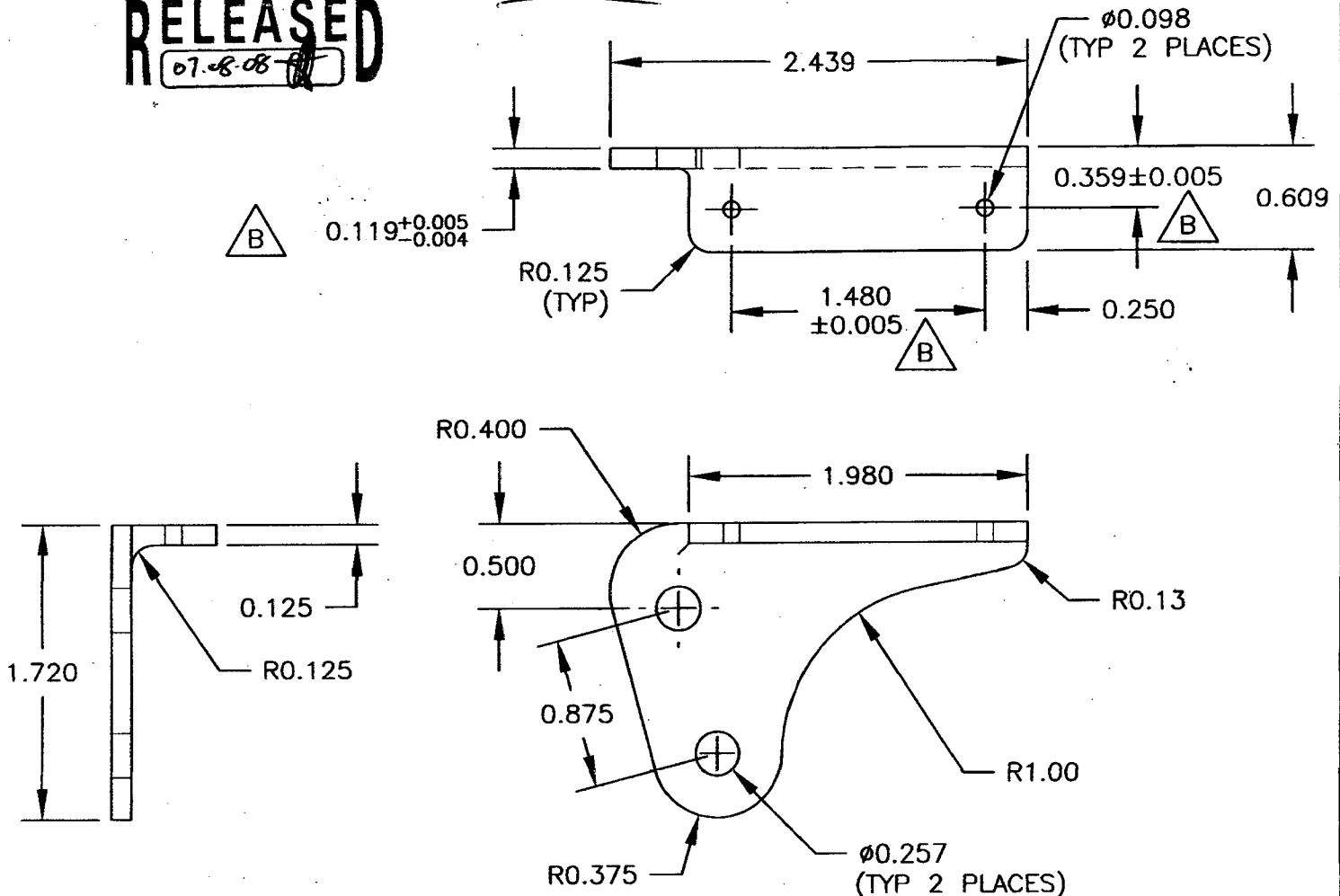
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.098	✓			
0.359	+/-0.005	.361	✓			
0.609	+/-0.010	.612	✓			
0.250	+/-0.010	.257	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	R.125	✓			
0.119	+0.005/-0.004	.121	✓			
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.980	✓			
R0.13	+/-0.030	R.125	✓			
Ø0.257	+0.005/-0.000	Ø.258	✓			
R0.375	+/-0.010	R.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.501	✓			
R0.400	+/-0.010	R.400	✓			
R1.00	+/-0.030	R.100	✓			
1.720	+/-0.010	1.720	✓			
R0.125	+/-0.010	R.125	✓			
0.125	+/-0.010	.126	✓			

<b>Measured by:</b>	<i>anf</i>	<b>Audited by:</b>	<i>MMW</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	<i>09/08/20</i>	<b>Date:</b>	<i>09/08/21</i>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC <i>JA</i>	<i>BE</i>

**DART**

DESIGN <i>90</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

**RELEASED**  
07.08.08*w/o 51354.***D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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